

Work Order ID 73051

Wednesday, August 24, 2011 3:34:54 PM



Page 1

Item ID: D4419-1

Accept



Setup Start



Revision ID:

Stop



Item Name: Fwd Support Plate

Start Date: 8/25/2011 Start Qty: 10.00



Cust Item ID:

Required Date: 9/8/2011 Req'd Qty: 10.00



Customer:

Reference:

Run Start



Stop



Approvals: Process Plan: MF Date: 11-08-24 Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D4419	A

100

0.00



Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg
Dwg Rev: A
Prog Rev: A

2-Deburr if necessary

11/08/25

12

110

0.00



QC

QC2- Inspect parts off machine FAI/FAIB

Memo

0.00

Quality Control

11/08/25

12

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Page 2

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Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

120

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

Quality Control

8/25/2011

12

130

Identify as per dwg & Stock Location: ST B9.

0.00



Packaging

Memo

0.00

Packaging

8/27/2011

12x

88

11-08-27

140

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/8/2011

11/08/29

W/O:		WORK ORDER CHANGES					
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Picklist Print

Wednesday, August 24, 2011 3:34:52 PM

Page 1

Work Order ID: 73051



Parent Item: D4419-1



Parent Item Name: Fwd Support Plate


Start Date: 8/25/2011

Required Date: 9/8/2011

Start Qty: 10.00

Required Qty: 10.00

Comments: IPP REV:A NEW ISSUE 11-07-11 JLM VERIFIED BY:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S11GA  304/316 0.125 Sheet		Purchased	No				sf	55.5000		3.637895			



Location

Loc Qty

Loc Code

MAT020

55.5

117494

55.5

4.4 ~~70~~ 11/08/25

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
NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order: 73051
Description: Fwd support plate		Part Number: 4419-1
Inspection Dwg: 4419	Rev: A	Page 1 of 2

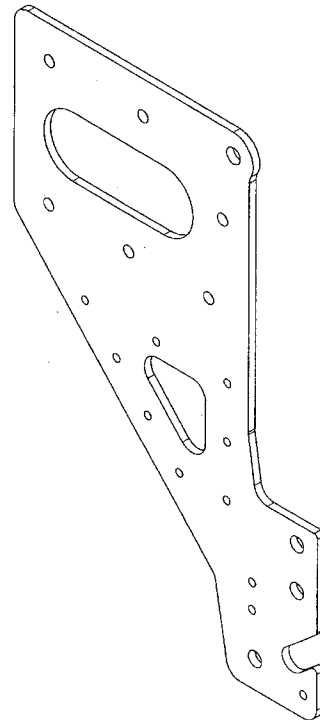
FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☒ Prototype

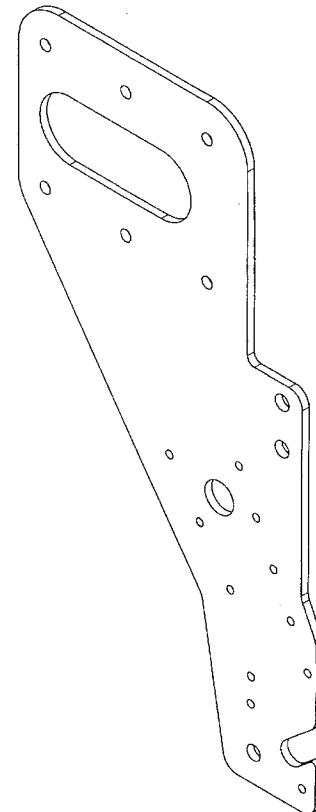
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
8.78	$\pm .030$	8.789	—		CNC 02	Vern
7.32	$\pm .030$	7.32	—		"	
4.10	$\pm .030$	4.106	—		RA26	Vern
3.25	$\pm .030$	3.252	—		"	"
1.20	$\pm .030$	1.212	—		"	
1.10	$\pm .030$	1.090	—		"	
.55	$\pm .030$.557	—		"	
2.80	$\pm .030$	2.797	—		"	
4.40	$\pm .030$	4.414	—		RA26	Vern
1.30	$\pm .030$	1.289	—		"	
5.70	$\pm .030$	5.712	—		CNC 02	Vern
4.35	$\pm .030$	4.357	—		RA26	Vern
5.71	$\pm .030$	5.717	—		CNC 02	Vern
.80	$\pm .030$.812	—		RA26	Vern
.390	$\pm .010$.387	—		RA26	Vern
1.91	$\pm .030$	1.901	—		RA26	Vern
$\emptyset .129$	$\pm .0005$	$\emptyset .129$	—		"	
$\emptyset .191$	$\pm .0005$	$\emptyset .192$	—		"	
$\emptyset .250$	$\pm .0005$	$\emptyset .250$	—		"	
$\emptyset .257$	$\pm .0006$	$\emptyset .258$	—		"	
.866	$\pm .010$.864	—		RA26	
1.750	$\pm .010$	1.753	—		"	
1.500	$\pm .010$	1.502	—		"	

Measured by: 	Audited by: 	Prototype Approval:
Date: 11/08/25	Date: 11/08/25	Date:

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	



D4419-1 FWD SUPPORT PLATE



D4419-3 AFT SUPPORT PLATE

73051

RELEASED
2011-07-28
JW

NOTES:

- 1) MATERIAL: 303/304/316 STAINLESS STEEL SHEET ANNEALED 2B, 0.125 THK
PER MIL-S-5059 OR AMS 5513/5524 OR ASTM A240 OR ASME SA240
REF DART SPEC M304S11GA OR M303S11GA
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART OSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT -1: 0.88 lbs
-3: 1.10 lbs

A		NEW ISSUE		AJS	11.07.06
REV.		DESCRIPTION		BY	DATE
DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		REV. A	
DRAWN	AJS			SHEET 1 OF 3	
CHECKED	UP	DRAWING NO. D4419		SCALE	
MFG. APPR.	E	TITLE		NTS	
APPROVED	MP	BASKET SUPPORT PLATES			
DE APPR.	JW	DATE 11.07.06		COPYRIGHT © 2011 BY DART AEROSPACE LTD	
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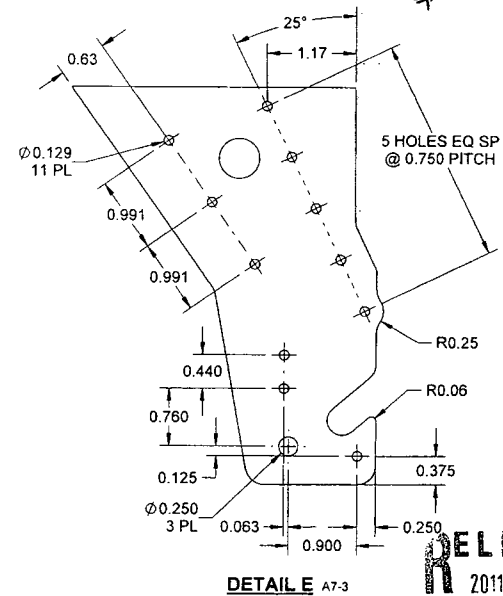
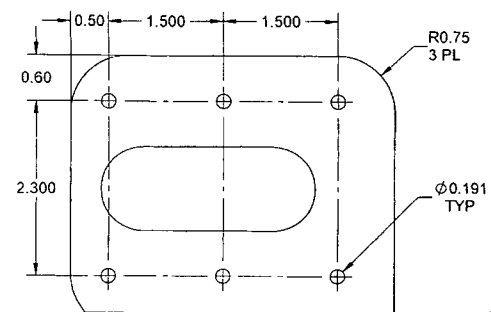
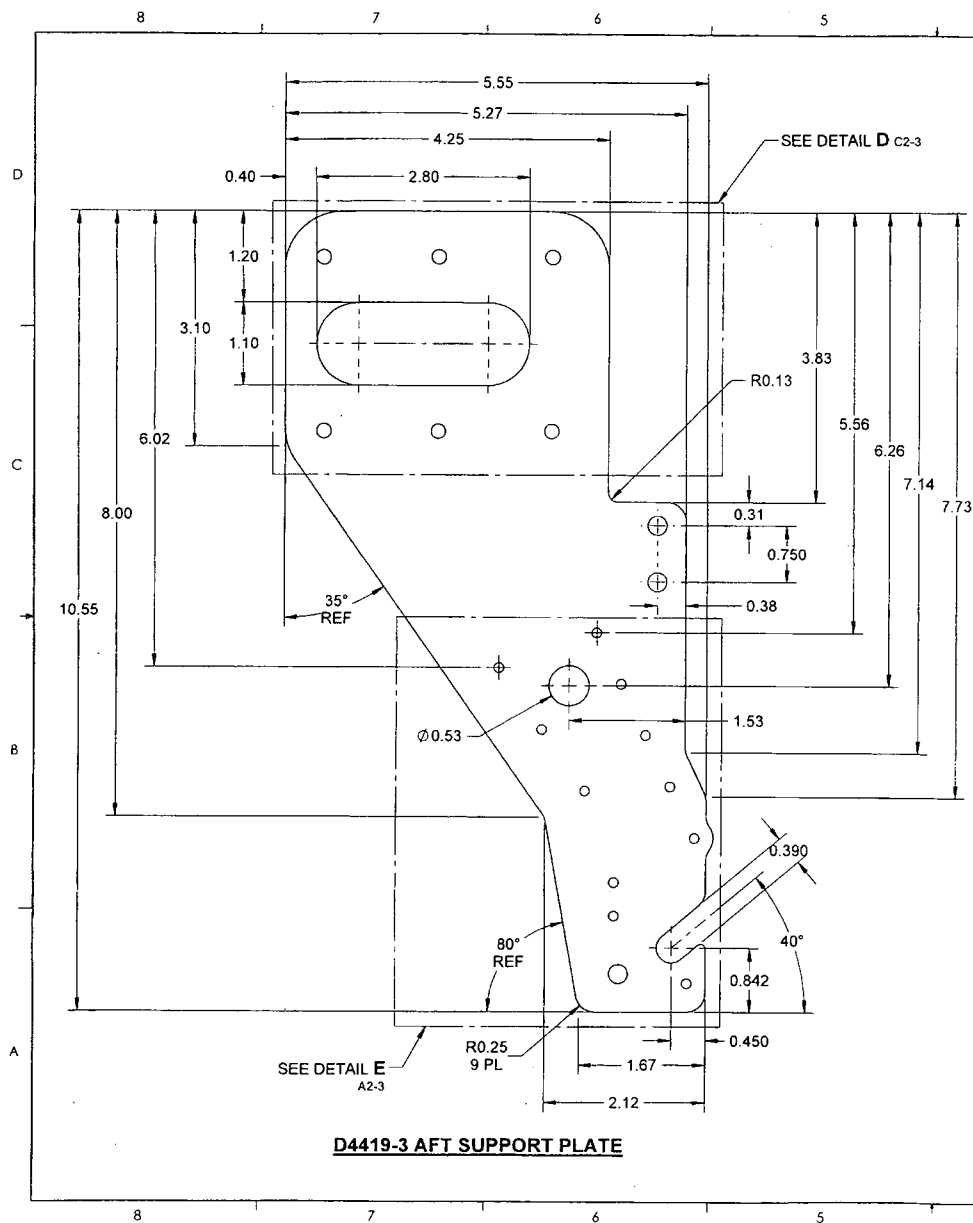
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DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED	QI	DRAWING NO.	REV. A
MFG. APPR.	E	D4419	SHEET 3 OF 3
APPROVED	MP	TITLE	SCALE
DE APPR.	#	BASKET SUPPORT PLATES	NTS
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RELEASED
2011-07-08
JAN

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